Page 1

3 April-10-12 7:56:22 AM

**Required Date:** 24/04/2012

Item ID:

D350-636-012

Accept

\*N900040100\*

Setup Start

**Revision ID:** 

Item Name: **Start Date:** 

Skidtube RH 10/04/2012

Start Qty: 1.00

**Req'd Qty:** 1.00

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Sequence ID/

Process Plan: ULT

Operation

Tooling:

Date:

Run

QC:

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Reject

Qty

Accept

Qty

Insp.

Stamp

**Work Center ID** Description **Draw Nbr Revision Nbr** D2750 F C D3492

100

\*100\* DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

Tool # Plan

Code

Reject

Number



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W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES								
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	
Resolution:		Disposition:	QA: N/C Closed		Date:	

NCR:		,	WORK ORD	ER NON-CONFORMANC	E (NCR)			
·		Description of NC		Corrective Action Section B			Ammroval	Annewal
DATE	STEP	Section A	Initial Chief Eng	Initial   Action Description   Sign &		Verification Section C	Approval Chief Eng	Approval QC Inspector
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April-10-12 /:	36:22 AM											
Item ID: Revision ID:	D350-636-0	12	. <del></del> -	Accept	*N900	<b>104</b> 0	1100	)*	•	Start Stop	*N	S1*
Item Name:	Skidtube RH		-I- 4	al.					3	otop	*N	S2*
Start Date: Required Date	10/04/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1 *1		Cust Item Customer							
Reference:		2104 a &c	"1		Customer	•						
Approvals:	Process Pla	in:	Date:	Tooling:		 Date:		I		tart	*N	R1*
	<b>QC</b> :		_ Date:	SPC (Y/N):	I	Date:			S	Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp
*110*		Skidtubes		0.00								
Skidtubes Skidtubes		Memo 1- Pick Di	2600-3 Bent	0.00	,							
			FWD and AFT ends, poer dwg D2750	remove bending marks. Scribe bat	ch# inside							
		3- Drill pi deburr.	lot holes for blade fitti	ng bolt holes using DT8983. Oper	to 0.500",							
		4- Locate fitting	DT8329 off of blade f	itting bolt holes and drill pilot hole	es for blade			\_	. ,	1		·.
				using DT9616. Ensure proper posi					B 12/c	99/1	1	£
				(5) 2750 sheet 4 (D2750-2 details).Di t side only DT8863B for second s						1		बैं कर्न र -
		7- Clecko ***SECO	DT8863B on second s ND SIDE***	ide of tube and drill pilot holes for	detail B.			/ `.				-
		location ho	oles to 0.500" (total of	0 0.375" (4 holes per side)and blac 4 holes per side) as per dwg D275 stail L to 0.500" (8 holes per side)	0 .Open up							

0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORDI	ER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector
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		A						

Quality Control

Memo

Page 3

April-10-12 7:56:22 AM Item ID: D350-636-012 Accept Setup Start \*N900040100\* **Revision ID:** Item Name: Skidtube RH Start Qty: 1.00 **Start Date:** 10/04/2012 **Cust Item ID: Req'd Qty:** 1.00 **Required Date: 24/04/2012 Customer:** Reference: Run Process Plan: Approvals: Date: **Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Tool ID **Operation** Set Up/ Tool # Plan Accept Reject Reject Insp. Work Center ID **Description** Qty Qty **Run Hours** Code Number Stamp 11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: M 12-Grind welds flush as per Dwg D2750 120 QC10- Inspect visual per QSI004- ground welds 0.00 \*120\* 0.00 Memo Quality Control 130 QC5- Inspect part completeness to step on W/O 0.00 Si7/04/12

W/O:			W	ORK ORDER CHANG	ES				r B
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		esolution:							
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCI	<b>R</b> )			
DATE	STEP	Description of NC	Corrective Action Section B			Verific	ation	Approval	Approval
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Page 4

Āpril-10-12 7:56:22 AM

Item ID:

D350-636-012

Accept

\*N900040100\*

Setup Start

**Revision ID:** 

Skidtube RH Item Name:

**Required Date:** 24/04/2012

**Cust Item ID:** 

**Start Date:** 

10/04/2012

Start Qty: 1.00

Req'd Qty: 1.00

**Customer:** 

Tool ID

Reference:

Approvals: **Process Plan:**  Date:

**Tooling:** 

Date:

Run

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Sequence ID/

**Work Center ID** 

Description Chemical Conversion Coat per QSI005 4.1 **Run Hours** 

Tool # Plan

Accept Qty

Reject Reject Qty Number Stamp

Insp.

140

\*140\* HandFinish

Memo

Operation

0.00

0.00

Code

Hand Finishing

150

QC7-Inspect Chemical Conversion Coat

0.00

\*150\* QC

Quality Control

Memo

0.00

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W/O:			WO	RK ORDER CH	ANGES					
DATE	STEP	PROC	CEDURE CHAN	IGE		Ву	Date	Qty_	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	_ Fault Categ	ory:	NCI	R: Yes N	o DQA:	·. •	_ Date: _	
	R	esolution:	_ Disposition	•	QA	N/C Clos	sed:		Date:	
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DATE	STEP	Description of NC	Initial	Corrective Action Action Descrip	Section B	Sign &	Verificat		Approval	Approval
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10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

Dart	<b>Aeros</b>	pace	Ltd
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W/O:		WORK ORDER CHANGES								
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Resolution: Disposition:						Date: _				
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DATE	STEP	<b>Description of NC</b> Section A	Initial	Corrective Action Section Action Description	n B Sign &	Verification	Approval	Approval		
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Work Order ID 82796 Page 6 April-10-12 7:56:22 AM Accept \*N900040100\* Setup Start Item ID: D350-636-012 **Revision ID:** Skidtube RH Item Name: 10/04/2012 Start Qty: 1.00 Start Date: **Cust Item ID: Required Date:** 24/04/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Date: Tooling: Date: Approvals: Stop QC: Date: SPC (Y/N): Date: Set Up/ Tool ID Tool # Plan Reject Reject Insp. Sequence ID/ Operation Accept Number Stamp Code Qty Qty **Work Center ID** Description **Run Hours** dwg D2750 12-Deburr holes OC10- Inspect visual per QSI004- ground welds 0.00 170 \*170\* QC Memo Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

7

8 izlauli7

\*180\* OC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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Part No:		PAR #: Fault Category		gory:	NCR: Yes No DQA:				
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DATE	STEP Description of NC Section A		Initial Chief Eng	Action Descrip	otion	Sign &	Verification Section C	Approval Chief Eng	Approva QC inspect

	l _	Description of NC		Corrective Action Section B	Verification	A	Ammerical	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC inspector
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210

QC3- Inspect Part Finish

0.00

\*21**0**\*

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

OVEN TEMPERATURE:

FINISH TIME:

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W/O:		WORK ORDER CHANGES					
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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April-10-12 7:56:22 AM

Item ID: Revision ID: Item Name:	D350-636-0 Skidtube RH	12		Accept	*N900	<b>04</b> 0	100	)*	Setup	Start Stop	*N *N	S1* S2*
Start Date: Required Date Reference:	10/04/2012 : 24/04/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	ite:			Run	Start	*N	R1*
	QC:_	· · · · · . · . · .	Date:	<b>SPC (Y/N):</b>	Da	ite:				Stop	*N	R2*
Sequence ID/ Work Center I	<b>D</b>	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
230 *230* HandFinish		HandFinishing <b>Memo</b>		0.00	·	,			B		R	12/01/12
Hand Finishing			erts as per dwg D2750					RH				
		•	or Foreign Objects									
		batch:	ide of tube with "LPS-3"									

4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241 BATCH: | Z | ZZ |

EXP DATE: 13/01

5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 155-0'ring lube batch: 155-0'ring lube batch: 155-0'ring lube

6-Coat all exposed fasteners with "LPS Procyon" batch: 11-1576

Dart Aerospace L
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W/O:			GES							
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Dat	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	·	PAR #:	Fault Cate	egory:	_ NCR: Yes	No	DQA:	Date: _		
	Resolution: Disposition: QA:				_ QA: N/C	Closed:		Date: _		
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)				
DATE	STEP	Description of NC	1-141-1	Corrective Action Section		Sign & Verification		Approval	Approval	
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	Work Order ID 82796  April-10-12 7:56:22 AM			796*						Page 9
Item ID: D350-6. Revision ID: Item Name: Skidtube			Accept	*N900	0040100	<b>)</b> *	Setup	Start Stop		S1* S2*
Start Date: 10/04/20 Required Date: 24/04/20 Reference:	- ·	*1* *1*		Cust Item   Customer:	ID:					.,
	s Plan:	Date:	Tooling: SPC (Y/N):		ate:			Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center ID 240 *740* QC	Operation Description QC5- Inspect part comp	leteness to step on W/O	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accept Qty	t Rejec Qty		Reject Number	Insp. Stamp
Quality Control  250  *250* Packaging	Pick Kit <b>Memo</b>		0.00							12/4/201
260 *260* QC	QC4- 100% Inspect kits <b>Memo</b>	for completeness	0.00	i7/al/20						

Quality Control

W/O:	VO: WORK ORDER CHA		NGES					•			
DATE	STEP	PRO	CEDURE CH	HANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Ca	tegory:	NCR	CR: Yes No DQA: Date:					
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DATE	STEP	Description of NC Section A	Initial	Corrective Action S Action Description	Section B	Sian &	Sign & Verification Section C		Approval	Approval	
, , <u></u> <u></u>		Section A	Chief Eng	Chief Eng		Date	Secu	on C	Chief Eng	QC Inspector	
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Page 10

April-10-12 7:56:22 AM

Item ID:

D350-636-012

Accept

\*N900040100\*

Setup Start

Revision ID:

**Start Date:** 

Item Name:

**Required Date:** 24/04/2012

Skidtube RH

10/04/2012 Start Qty: 1.00

**Req'd Qty:** 1.00

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

**Process Plan:** 

Date:

**Tooling:** 

Date:

Run

QC:

Date:

SPC (Y/N):

Date:

Stop

Qty

Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours** 

Tool #

Plan

Code

Accept Qty

Reject Reject

Insp. Number Stamp

270

\*270\*

Packaging

Packaging

Packaging

Memo Package as per PPP D350-636-012

280

QC21- Final Inspection - Work Order Release

0.00

QC Quality Control

Memo

0.00

112021-23

W/O:	WORK ORDER CHANG			<b>BES</b>	ES						
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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### **Picklist Print**

Âpril-10-12 7:56:25 AM

. Work Order ID: 82796

D350-636-012

Parent Item Name: Skidtube RH

\*82796\*

\*D350-636-012\*

**Start Date:** 10/04/2012

**Required Date: 24/04/2012** 

Start Qty: 1.00

Required Qty: 1.00

Comments:

Parent Item:

IPP Rev:102.09.25Rearranged procedure stepsKJ

IPP Rev:J 06-03-29 As per Rev D As per dsi9343 IPP Rev:K 06-07.13

Added SS Wearplates(Rev E) JLM Verified By:EC IPP Rev:L 07-07-28

update steps 4.13 DD verified by:EC IPP Rev:M 08-04-22

IPP Rev:N 08-09-23 revl 10.06.22 revise seg110 DD verf:EC IPP Rev:P 10.10.01 as

per IIN revH DD verf:EC

date steps 1,1.	DD formed of .Do	
vF as per dwg	DD verified by:ec	IPP Rev:0
250	IDD D D	10 10 01

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT	,	Manufactured	No			110	Each	27.0000	1	1			
*D2600-3-	RFNT*				•				**	E	2 12/0	4/11	···· ··· ····· ····· · ·

		Location	Loc	c Qty	Loc Code			
		LG		27				
		66875		7			The second secon	
		73253		1				
		75021		1				
		75022		1				
		75023		1				
		81330		4				
		82347		12				
Manufactured	No		110	Each	42.0000	1	1	,

Loc Qty Loc Code Location LG002 42 62715 1 70881 3 78900 38

BE12/04/12

Page 1

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W/O:			WC	RK ORDER CHAN	GES				ra.
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr.//	Approval QC Inspector
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DATE	STEP	Description of NC Section A	Initial	Corrective Action Se Action Description	ection B	n&∣ <sub>S∞</sub>	ication	Approval Chief Eng	Approval QC Inspector
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#### **Picklist Print** Page 2 Åpril-10-12 7:56:25 AM Work Order ID: 82796 \*82796\* \*D350-636-012\* D350-636-012 Parent Item: **Start Date:** 10/04/2012 **Required Date: 24/04/2012** Parent Item Name: Skidtube RH Start Qty: 1.00 Required Qty: 1.00 D2739 160 Each 3.0000 No Manufactured \*\* 350 l Beam Loc Qty Loc Code Location 72155 81508 82122 D2743 160 Each 314.0000 Manufactured No \*\* Crossbolt Spacer Location Loc Qty Loc Code LG001 314 67766 68251 64 73403 74445 2 78603 30 79517

\*D3490-3\*

Manufactured

No

Cross Bolt Spacer

D3490-3

Locatio	<u>.</u>	Loc Qty
LG		68
	82016	68
LG001		2
	78800	2

160

Each

Loc Code

70.0000

4

BF-12-04-15

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DATE	STEP	Description of NC Section A	<b>Initial</b> Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sigr	ı& ∣ <sub>Seci</sub>	cation tion C	Approval Chief Eng	Approval QC Inspector
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### **Picklist Print**

April-10-12 7:56:25 AM

· Work Order ID: 82796

Parent Item:

D350-636-012

Parent Item Name: Skidtube RH

\*82796\* \*D350-636-012\*

**Start Date:** 10/04/2012

**Required Date: 24/04/2012** 

Start Qty: 1.00

Required Qty: 1.00

D3490-1

D3631-1

D3791-1

\*D3490-1\*

Cross Bolt Spacer

Manufactured

160

Each

104.0000

Loc Code

Loc Code

Loc Code

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BE12/04/15

		<b>Location</b>		<u>Lo</u>	e Qty
		LG			95
		81	976		95
		LG001			9
		62	2450		2
		74	1875		4
		77	7042		3
Manufactured	No			230	Each

227.0000

\*\*

12/04/19.

Washer

Manufactured	No

Loc Oty Location FG 100 100 81874 ST072 127 68062 2 75548 125 230 Each

25.0000 \*\*

Wearplate

<u>Location</u>	Loc Qty
FP002	25
62239	2
78897	7
82168	16

Dail Ac	ospace	5 Ltu								
W/O:			WC	RK ORDER CHAN	GES					<u> </u>
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR:	Yes I	No <b>DQ</b>	A:	Date: _	
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (	NCR				
DATE	STEP	Description of NC Section A	Initial	Action Description	ection B	Sign &	Verific Secti		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date				
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Picklist Print April-10-12 7:56:25 AM						Page 4
• Work Order ID: 82796  Parent Item: D350-636-012  Parent Item Name: Skidtube RH			2796* 350-636-0 <i>*</i>	12*	<b>Start Date:</b> 10/04/20 <b>Start Qty:</b> 1.00	Required Date: 24/04/2012 Required Qty: 1.00
D3793-3 *D3793-3* Wearshoe	Manufactured	No		230 Each	30.0000 1 1 ** 1	D 12/04/19
Treatistic Control of the Control of			Location FP001 80434 82166 FP002 78935	Loc Otv  23 11 12 7 7	Loc Code	
*M\$21043-6 *M\$21043-6*	Purchased	No	78733	230 Each	765.0000 4 4 4 **	1 (20) 12/04/19.
			Location FG 103693 ST301 112314 117887 118384 120308	20 20 745 39 6 200 500	Loc Code	
D3794-1 *D3794-1* Gasket	Manufactured	No		230 Each	39.0000 I 1 ** (_	1464/19,
			Example 12	23 23 16 4 12	Loc Code	

WORK ORDER CHAI									•	
DATE	STEP	PRO	OCEDURE CHANGE By Date					Qty Approval Chief Eng / Prod Mgr Appro		
Part No:		PAR #:	Fault Ca	tegory:	NCR: Y	es No	DQA:	Date: _		
	R	esolution:	Disposit	ion:	_ QA: N/C	Close	ed:	Date: _	<u> </u>	
NCR:		٧	VORK OR	DER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC Section A	initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sig	n &	Verification Section C	Approval Chief Eng	Approval QC Inspector	
	_		Other Eng	Gillot Elig						
·										
					,					
	·	_								

Åpril-10-12 7:56:25 AM

. Work Order ID: 82796

D350-636-012

Parent Item Name: Skidtube RH

\*82796\*

\*D350-636-012\*

**Start Date:** 10/04/2012

**Required Date: 24/04/2012** 

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Parent Item:

Purchased

No

230

259.0000 Each

\*NAS1611-010\* O-RING

<b>Location</b>	Loc	<u>Qty</u>	Loc Code			
FP		50		-		1
110915		0				
120770		50				
FP001		209		_		
110915		14				
117460		8				
118077		1				
118612		3				
119438		47				
120986		50				
121166		36				
121259		50				
	250	Each	63.0000	1,	1	V

Loc Qty

-10

Blade, 350 Skidtube

Manufactured

\*\*

Loc Code

JB 12/04/20

ST466 73 71856 76984 22 40 79516

Location

ST

	. oopaoo								
W/O:			WC	RK ORDER CHANG	GES				•.
DATE	STEP	PR	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	NCR: Y	es No	DQA:	Date: _	
Resolution:			Disposition	QA: N/C	Date: _				
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC	Corrective Action		Section B		erification	Approval	Approval
	J	Section A	Initial Chief Eng	Action Description Chief Eng		n & Tate	Section C	Chief Eng	QC Inspector
						ŀ			
							:		
							į		
	1		i		Ì	1			1

Äpril-10-12 7:56:25 AM

. Work Order ID: 82796

\*NAS1515H3L\*

\*NAS1611-013\*

Parent Item:

D350-636-012

Parent Item Name: Skidtube RH

\*82796\*

\*D350-636-012\*

**Start Date:** 10/04/2012

**Required Date: 24/04/2012** 

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

WASHER

Purchased

No

230

Each

190.0000

Location		Lo	c Oty	Loc Code			
FG			40				
	102472		40				
ST277			150				
	118686		3				
	119438		1				
	120360 🗸		96				
Ŧ	121243		50				
		230	Each	218.0000	8	8	

NAS1611-013

O-RING

Purchased

No

Location	Loc Qty	Loc Code
FP001	218	
116582	5	
117291	2	
117887	53	
119623	36	
120910	4	
121166	68	
121259	50	

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April-10-12 7:56:25 AM

**Shop Packet Print** 

Page 6

<b>-</b> 411.710	·oopaoo								, • .
W/O:			WC	RK ORDER CHANG	GES				
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:PAI Resolution:		PAR #:	Fault Cate	gory:	NCR: Yes	_ Date: _	Date:		
		solution:	Disposition	QA: N/C C	osed:	Date:			
			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC			tion B	Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Secti		Chief Eng	QC Inspector
		- W							
				-			* **		

April-10-12 7:56:25 AM										Page 7
Work Order ID: 82796  Parent Item: D350-636-012  Parent Item Name: Skidtube RH			2796* 350-636-0	12*		S	taut Datas	10/04/2012	 D	24/04/2012
Parent Item Name: Skidtube KH							tart Date: Start Qty:	10/04/2012 1.00		red Date: 24/04/2012 ired Qty: 1.00
AN3C6A	Purchased	No		230	Each	499.0000		4	-	
*AN3C6A*							**	<i>ا</i> ر. ا	P	12/04/19.
			<b>Location</b>	Lo	<u>e Qty</u>	Loc Code				
			FP001 111982		1					
			ST351		498					
			111982		2			4.44		
			116419		23					
			116549 116704		2 12				****	
			117619		10				_	
			117688		l					
			117872		5				_	
			118422 119449		13 21				_	
	•		120423		9					
			120693 🗸		400					
NAS1149C0832R	Purchased	No		230	Each	293.0000	1	1	_	
*NAS1149C08:	32R*						**			12/04/19
			<b>Location</b>	Loc	e Qty	Loc Code				
			ST297	,	293			the same and the s		
			114915		293					
D3536-25	Manufactured	No		230	Each	22.0000	t	1		1 1
*D3536-25*							**			12/04/19.
			<b>Location</b>	Loc	<u>Oty</u>	Loc Code				
			FP 01242		14					
			81342 <b>✓</b>		14					
			FP002 78902		8 8				_	
			10302		o				_	
April-10-12 7:56:25 AM		· · - · · <del> · · · ·</del>	Shop Pa	cket Print						Page 7

**Picklist Print** 

Dail Ac	ospace L	.tu										
W/O:			WO	RK ORDER CHANG	GES				•			
DATE STEP		PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
			W. C. Andrews									
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _				
Resolution:			Disposition	QA: N/C Closed: Da				te:				
NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
D.175		Description of NC			tion B	Verific	cation	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	Verification Section C	Chief Eng	QC Inspector			
		· · · · · · · · · · · · · · · · · · ·										
							!					

Picklist Print Äpril-10-12 7:56:25 AM										Page 8		
Work Order ID: 82796		*8	2796*									
Parent Item: D350-636-012 Parent Item Name: Skidtube RH			*D350-636-012*				<b>Start Date:</b> 10/04/2012			Required Date: 24/04/2012		
						S	Start Qty: 1	.00	Required Qty: 1.00			
D3794-3 *D3794-3* Gasket	Manufactured	No		230	Each	23.0000	**	1		1404/19		
•			Location FP002 74530 80436	<u>Lo</u>	23 2 21	Loc Code						
*AN3C5A *Bolt	Purchased	No	·	230	Each	1,596.000	34 **	34 3 4	(20)	12/04/19		
D3537-1	Manufactured	No	Location FP001 115835 ST350 116419 117343 117764 117872 119749 120423.4 1210168 121255	<u>Lo</u> .	7 7 1589 28 13 7 2 23 516 500 500 Each	<u>Loc Code</u> 75.0000	3					
*D3537-1 *D3537-1*	ivianuiactured	INU		230	Lacii	73.0000	**	<u>3</u>	(P)	12/04/19		

\*D3537-1
Wearpad

Loc Qty Loc Code FG 10 79833 10 FP002 65 69817 5 80337 11 81361 49

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
						F Tod Wgi							
			<u> </u>										
Part No:		PAR #:	Fault Cat	egory:	NCR: Yes No DQA: Date:								
Resolutio		esolution:	Dispositi	on:	QA: N/C Clo	A: N/C Closed: Date:							
NCR:		V	VORK ORI	DER NON-CONFORMA	NCE (NCR)								
DATE	OTED	Description of NC		Corrective Action Section		Verification	Approval	Approval					
DATE	STEP Description of NC Section A		Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector					
	:												

#### **Picklist Print**

April-10-12 7:56:25 AM

, Work Order ID: 82796

Parent Item:

D350-636-012

Parent Item Name: Skidtube RH

\*82796\*

Location FP001

Location

FP-A

\*D350-636-012\*

**Start Date: 10/04/2012** 

**Required Date: 24/04/2012** 

Page 9

Start Qty: 1.00

Required Qty: 1.00

D3535-25

No Manufactured

230

Each

22.0000

Loc Code

\*\*

\*D3535-25\*

Wearshoe

D3492-3

Manufactured No

11 230 Each

Loc Oty

Loc Qty

22

10

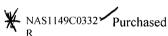
69.0000 \*\*

\*D3492-3\* Plug

AN960C10L

washer

D3488-042



Manufactured

No

No

121255-

69 69 Each

Each

0.0000

15.0000

Loc Code

Loc Code

38

\*\*

\*\*

\*AN960C10L\*

Blade Fitting Assembly, RH

Location Loc Qty FP002 15 62003 1 75068 8 77015 6

230

38

W/O:			WC	RK ORDER CHANG	BES			· · · · · · · · · · · · · · · · · · ·	s.
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
						10			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
	Re	solution:	Disposition	n:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCI	R)			.,
DATE	STEP	Description of NC			tion B	Verific	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	Secti		Chief Eng	QC Inspector
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						1			
	1 1					i		I	I

#### **Picklist Print** Page 10 April-10-12 7:56:26 AM \*82796\* . Work Order ID: 82796 \*D350-636-012\* Parent Item: D350-636-012 **Start Date:** 10/04/2012 Parent Item Name: Skidtube RH **Required Date: 24/04/2012** Start Qty: 1.00 Required Qty: 1.00 230 2,461.000 38 ALS4-1032-225 Each Purchased No \*\* \*ALS4-1032-225\* Insert Location Loc Qty Loc Code ST281 2438 108696 146 62 110768 118386 55 118966 68 120671 107 2000 121269 23 ST282 120410 10 13 120451 230 Each 30.0000 D3492-1 No Manufactured \*\* 12/04/19 \*D3492-1\* Plug **Location** Loc Qty Loc Code FP002 30 69531 8 74444 2 76235 77037 16 26.0000 230 D3793-1 Manufactured No Each \*\*

\*D3793-1\*\*\*\*

 Loc Oty
 Loc Code

 FP001
 26

 78901
 10

 82171
 16

	•								
W/O:			WC	RK ORDER CHANG	ES				1
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							:		
Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR	3)			
DATE	STEP	Description of NC			Section B Verific			Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
									:

Picklist Print Äpril-10-12 7:56:26 AM										Page 1
Work Order ID: 82796  Parent Item: D350-636-012  Parent Item Name: Skidtube RH		*8279 *D350		112*				10/04/2012	-	red Date: 24/04/2012
*AN8C35A *AN8C35A*	Purchased	No		230	Each	104.0000 *	t Qty:	1	Requ	ired Qty: 1.00
		<u>Locati</u> FP002 ST346	115960 117834 118286 121275 114442	<u>Lo</u>	103 1 7 45 50 1 0	<u>Loc Code</u>				
MS21083C8 *MS21083C8*	Purchased	No	115960	230	1 Each	105.0000	1 <b>*</b>	1 1	er.	1404/19
		Locati 304 FP002 ST303	121185	Loc	50 50 1 1 5 0 1 2 2 49 7 17 25	Loc Code				

Dari Ae	rospace	Lla								
W/O:			-	WORK ORDER	CHANGES					۵,
DATE	STEP		PRO	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	<b>:</b>		PAR #:	Fault Category:	NCR:	Yes	No DQ	A:	_ Date: _	
	Res	solution:		Disposition:	QA: I	WC C	losed:		Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Ammanal	Annuaval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto			
						•					
		<u> </u>									
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Äpril-10-12 7:56:26 AM

. Work Order ID: 82796

Parent Item:

D350-636-012

Parent Item Name: Skidtube RH

\*82796\* \*D350-636-012\*

Location

FP

FP001

Start Date: 10/04/2012

**Required Date: 24/04/2012** 

Start Qty: 1.00

Required Qty: 1.00

D2745

\*D2745\*

Bushing

No Manufactured

230

48.0000 Each

Loc Code

\*\*

2

12/04/19.

AN6C44A

\*AN6C44A\* BOLT

Purchased

Manufactured

No

No

79518 46 69529 76142

230 Each

Loc Qty

170.0000

\*\*

Location Loc Qty Loc Code FG 2 103964 ST343 168 120143 25 120465 23 121013 20

250

100

Each

51.0000 \*\*

JB 12/04/20

Location Loc Qty ST053 51 78839 27 82041 24

121167

Loc Code

78839

Dait Ac	ospace	Liu							
W/O:			WC	RK ORDER CHANG	ES				₹1
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	<u> </u>								
Part No		PAR #:							
	Re	solution:	Disposition	):	_ QA: N/C CI	osed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCF	<b>R</b> )			
DATE	CTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector
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							:		
	1				1				

April-10-12 7:56:26 AM

· Work Order ID: 82796

Parent Item:

D350-636-012

Parent Item Name: Skidtube RH

\*82796\*

\*D350-636-012\*

**Start Date:** 10/04/2012

**Required Date: 24/04/2012** 

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

105.0000

\*\*

Location	Loc	<u>Qty</u>	Loc Code			
304		50				
121185		50				
FP002		1				
115884		1				
ST303		5				
115884		0				
118077		1				
119309		2				
119638		2				
ST304		49				
120142		7				
120731		17				
121011		25			121011	
	250	Each	211.0000	2	2 /	
				ىل.		

NAS1149D0863J S1149D0863.I\*

Purchased

No

<b>Location</b>	Loc Qty	Loc Code	
ST298	211		
118078	36		
119307	75		119307
120308	100		,

	. Johaso								
W/O:			WC	RK ORDER CHANGE	ES				•
DATE	STEP	PRC	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del></del>									
Part No		PAR #:							
	Re	esolution:	Disposition	n:	QA: N/C Cld	osed:		Date: _	···-
NCR:		V	WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
		Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
							-	•	
								,	
							ļ		
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April-10-12 7:56:26 AM

• Work Order ID: 82796

Parent Item:

D350-636-012

Parent Item Name: Skidtube RH

\*82796\*

\*D350-636-012\*

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**Start Date:** 10/04/2012

**Required Date: 24/04/2012** 

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No 250

Each

46.0000

Loc Code

AN8C21A \*AN8C21A\*

Purchased

No

Loc Qty Location ST050 46 70697 2 77573 4 78835 40 250

121.0000 Each

\*\*

3B 12/04/20

Location	Loc Qty	Loc Code	
ST343	121		
118758	5		
120094	26		120094
121067	20		
121167	20		
121275	50		

		WC	RK ORDER CHANG	ES				•
STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<b>.</b>	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
Re	solution:	Disposition	n:	_ QA: N/C CI	osed:		Date: _	<del> </del>
		WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
OTED	Description of NC				Verific	ation	Approval	Approval
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date			Chief Eng	QC Inspector
							•	
						:		
						į		
		PAR #:	PAR #: Fault Category  Resolution: Disposition  WORK ORDE  STEP Description of NC Section A	PAR #: Fault Category:	STEP PROCEDURE CHANGE By  PAR #: Fault Category: NCR: Yes  Resolution: Disposition: QA: N/C CI  WORK ORDER NON-CONFORMANCE (NCF  STEP Description of NC Section A	STEP PROCEDURE CHANGE By Date  PAR #: Fault Category: NCR: Yes No DQA  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty  PAR #: Fault Category: NCR: Yes No DQA:  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty Chief Eng/Prod Mgr  PAR #: Fault Category: NCR: Yes No DQA: Date:  Resolution: Disposition: QA: N/C Closed: Date:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Section B Section C Section C Chief Eng (Prod Mgr)  PAR #: Fault Category: NCR: Yes No DQA: Date:

QTY QTY QTY -042 -043 -044 PART NUMBER DESCRIPTION -042 -043 D2750-041 X 350 SKIDTUBE ASSEMBLY, LH 350 SKIDTUBE ASSEMBLY, RH D2750-042 X D2750-043 350 SKIDTUBE ASSEMBLY, LH D2750-044 350 SKIDTUBE ASSEMBLY, RH D2739 WEB 8 8 8 8 D2743 SPACER 1 1 1 D2744 CAP 8 8 8 D2745 BUSHING D2750-SKIDTUBE WELDMENT, LH D2750-2 SKIDTUBE WELDMENT, RH D2750-3 SKIDTUBE WELDMENT, LH 1 D2750-4 SKIDTUBE WELDMENT, RH D3488-041 BLADE FITTING, LH 1 1 D3488-042 BLADE FITTING, RH 4 D3490-1 SPACER 4 SPACER 4 D3490-3 D3490-5 SPACER PLUG ASSEMBLY 8 8 8 8 D3492-041 8 8 D3492-043 PLUG ASSEMBLY 8 D3492-045 PLUG ASSEMBLY 8 1 D3535-25 WEARSHOE D3536-25 GASKET Æ ٦. 3 3 D3537-1 WEARPAD 8 8 D3631-1 WASHER 1 D3791-1 WEARPLATE 1 1 1 1 D3793-1 WEARSHOE 1 1 1 D3793-3 WEARSHOE Æ 1 1 1 D3794-1 GASKET 1 D3794-3 GASKET INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225) 38 ALS4-1032-225 38 38 Æ-34 34 AN3C5A 34 34 BOLT 4 4 4 AN3C6A BOLT 4 4 BOLT 4 AN6C44A 4 1 AN8C35A BOLT 38 38 38 38 AN960C10I WASHER 1 AN960C816L 1 1 WASHER 4 4 MS21043-6 NUT 1 MS21083C8 1 1 NULT

7

SHOP COPY **RETURN TO** ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER MCS NO. 32 196 MCS

3

F	QTY (3) D3791- D3794- ADD D3 WEARS (8 PL), D3488- ADD NO	1791-1 (ZN C8-1 HOF HOLES U	QTY (5) (ZN C8-1); D D535-13-235 (ZN C8-1); D D535-13-35 (ZN B8-1); ) DEF FWDJAFT SADDLE REMOVED RPDWARE OTY UPDATED (ZN B8-1); WARE UPDATED (ZN C1-8, 9, 10, 11); (ZN A6-1);	PH	08.07.16
E	CHANG ADD RU REMOV NAS151 REMOV	E TO STAINLE JBBER GASKE E QTY (38) NA 5H8L, REMOVI E QTY (2) MS2	SS STEEL WEARPLATES; TS; CHANGE INSERTS: ADD D3631-1; S1515H3L; REMOVE QTY (10) E D2741, QTY (2) AN960C816; 1083C8	СВ	07.05.17
D	ADD HO	LES AND SHAP	CERS FOR APICAL FLOATS; 133/9157	PH	06.01.05
С	ADD D2	750-3/D2750-4;	INCORPORATE D2738 AND D2740	CP	98.11.18
8	CHANG	E MS24694-S29	93 TO AN8-16A	CP	98.09.01
Α	NEW IS	SUE		DS	98.04.16
REV.			DESCRIPTION	BY	DATE
DESIG	DESIGN PA		DART AEROSPACE	USA	INC.
DRAW	4	RU	PORT HADLOCK,		
CHECK	O'LEGITED		DRAWING NO.	-	REV. F
MFG. APPR. D2750			D2750	s	HEET 1 OF 11

**GENERAL NOTES:** 

8

D

С

MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

4 NAS1515H3L

ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.

POWDER COAT WHITE (REF. 4.3.5.1) PER DART OSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

WASHER

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: N/A

IDENTIFICATION: N/A

WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS WELD PER DART QSI 004

4 4

INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (\$\phi 0.297) FOR WEARSHOE INSERTS

INSTALL ALSA-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:

MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF

POWDER COATING WITH MEK DEGREASER.

SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

08.07.16

TITLE

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APPROVED

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SCALE

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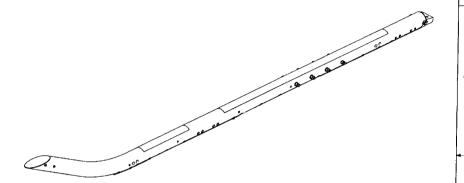
350 SKIDTUBE ASSEMBLY

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D2750-043 350 SKIDTUBE ASSEMBLY, LH

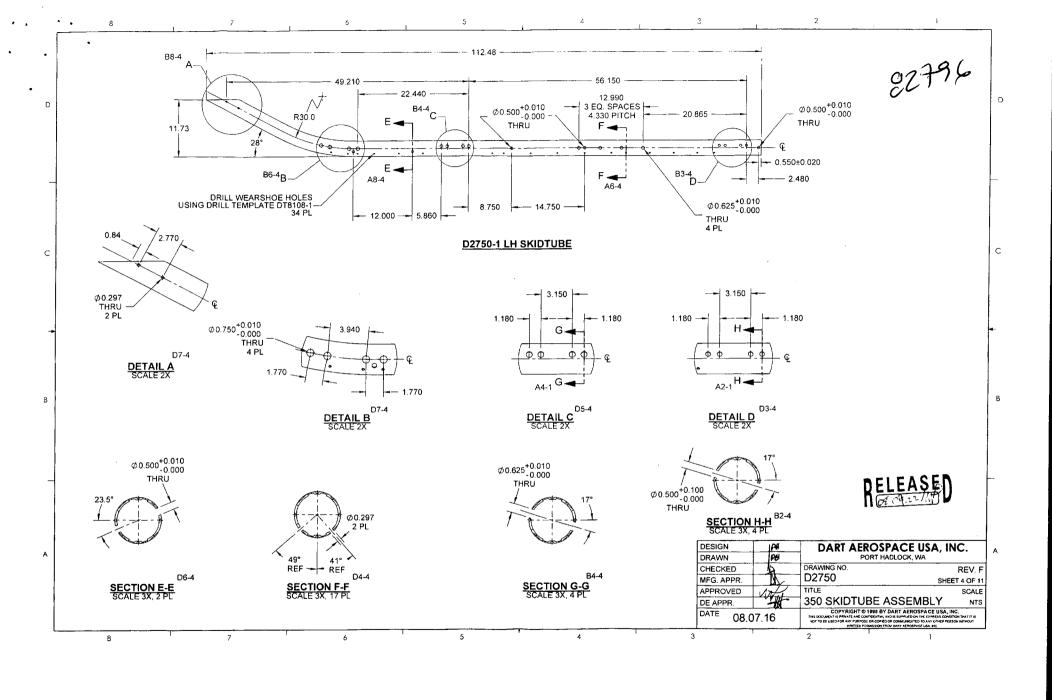
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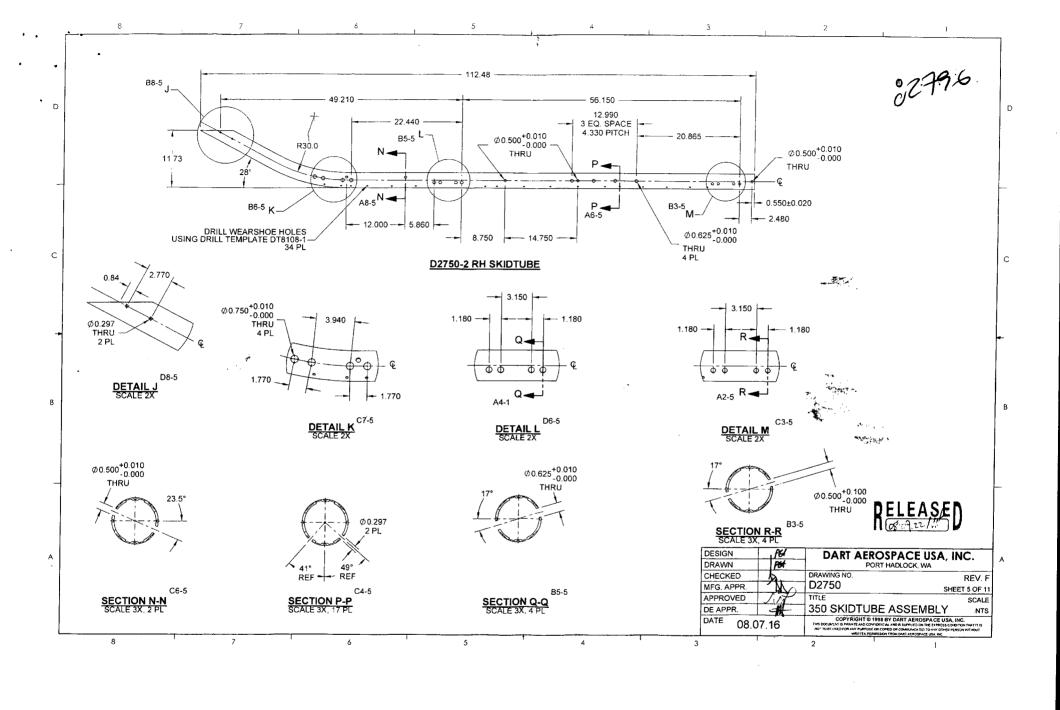
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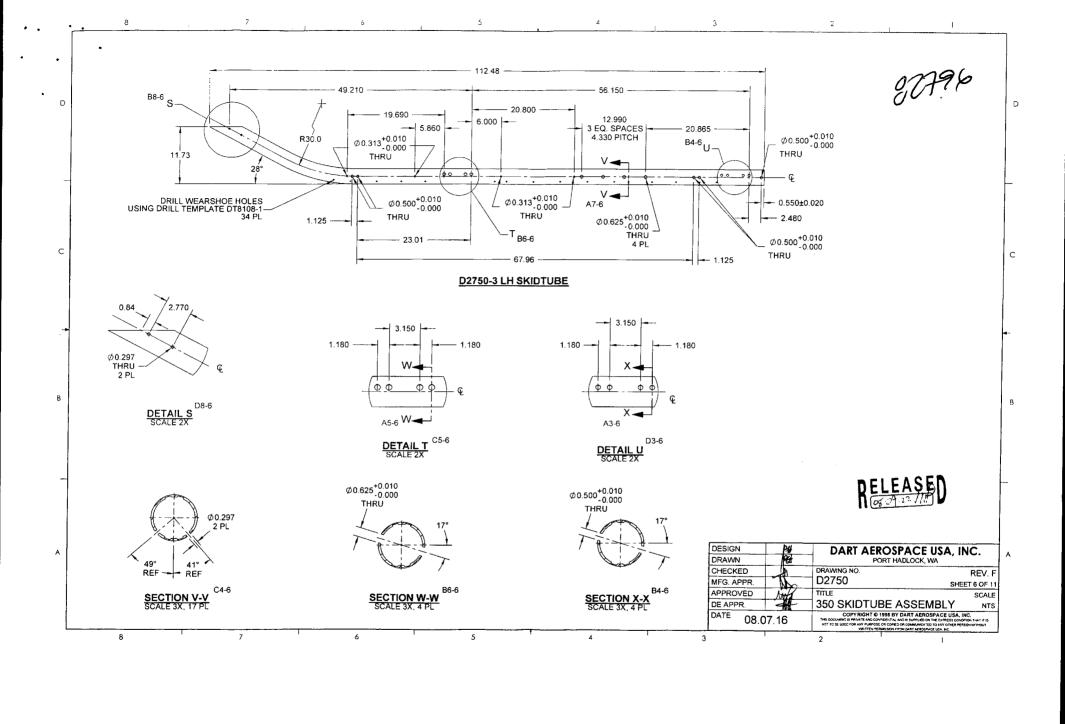
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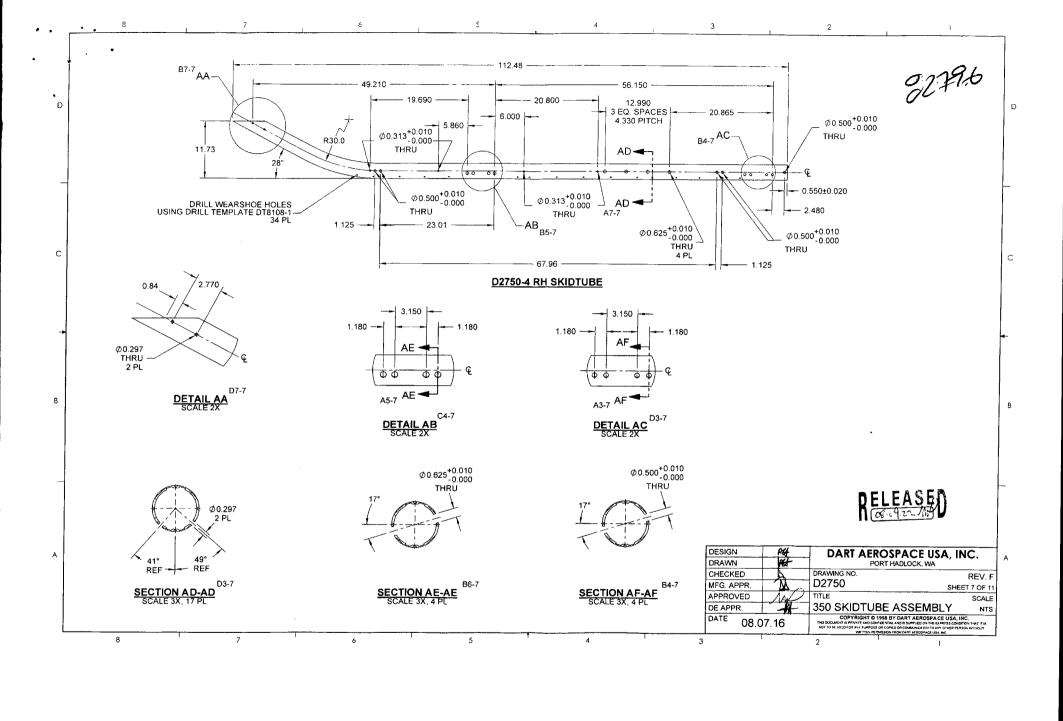
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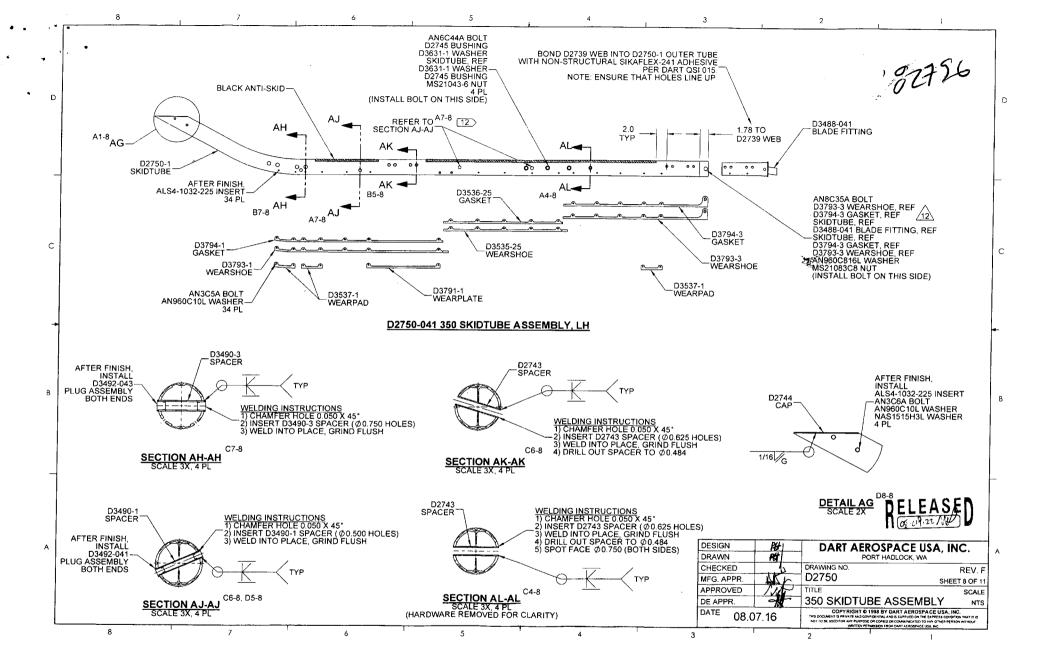
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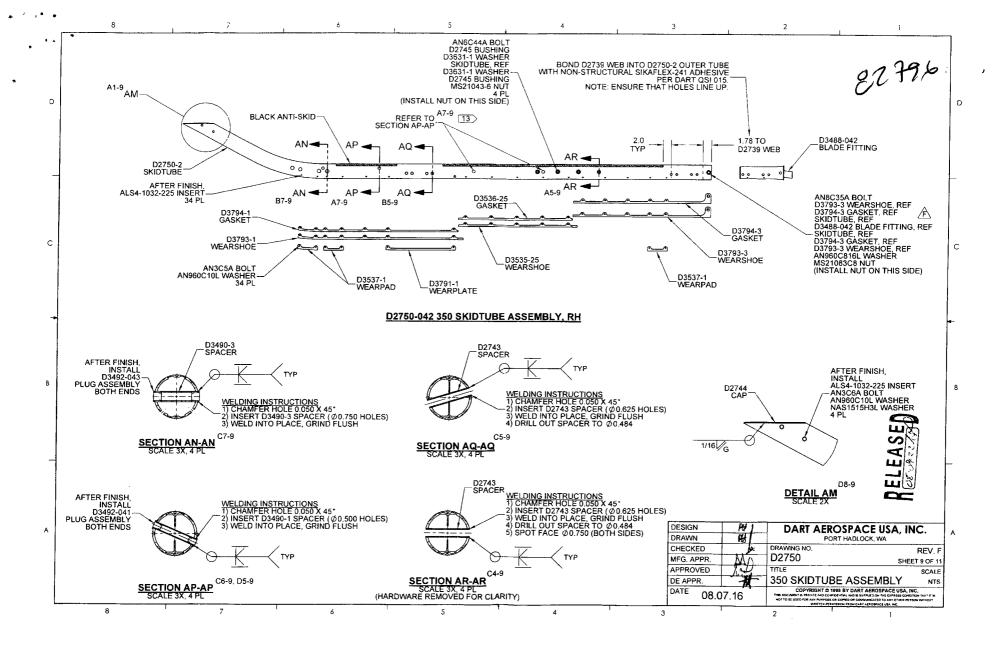
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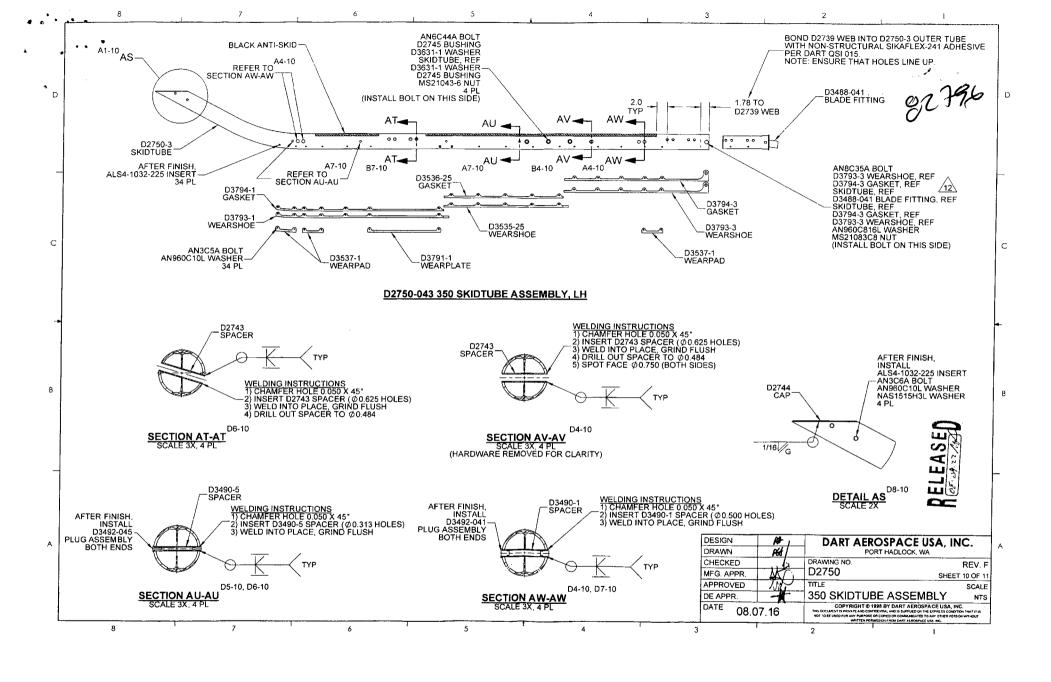
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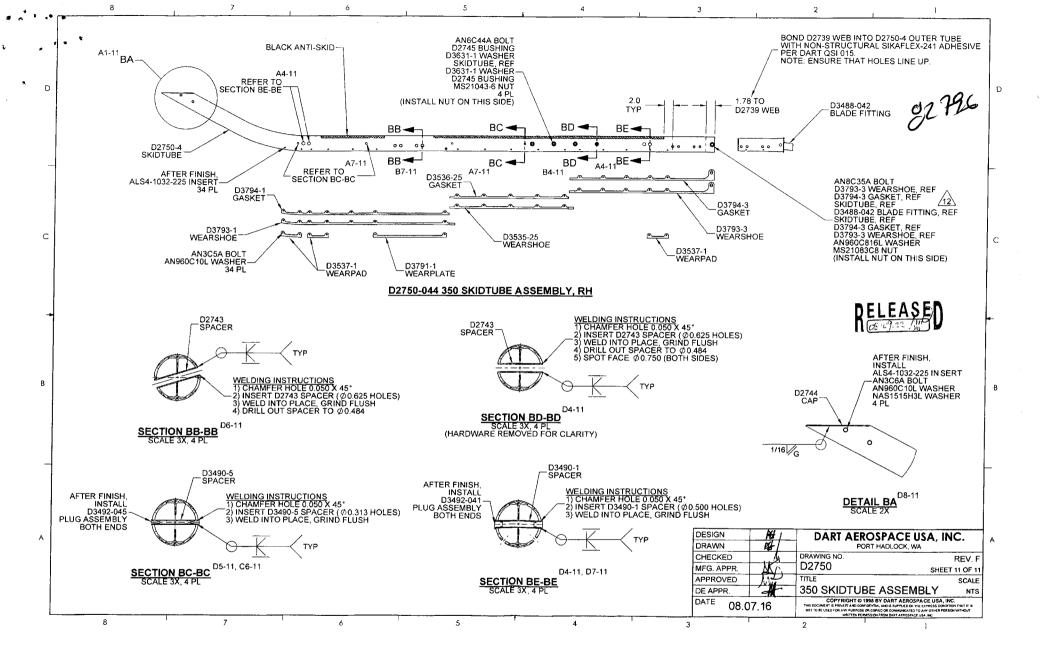
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NO. <u>289</u>

# AWS D17.1.2001 QUALIFICATION TEST RECORD

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Name: Barclay Elliott	
Job number: 81400	
Part number: 1350 - 636-	-016
Description: Shirtheuse	
Welding Process: Tig[ Mig[ ]	
Base materiel: Alum	
Current: AC DC ]	
TEST REOL	UIREMENTS AND RESULTS
	1
Visual:	pass[] fail[]
Penetration:	pass[ fail[ ]
UNACCEPTABLE	•
Cracks:	pass[ fail[ ]
Undercut:	pass[ fail[ ]
Pin holes:	pass[ fail[ ]
Overlap (cold lap)	pass[/] fail[]
Porosity (surface):	pass[] fail[]
Coloration:	pass[ fail[ ]
Color action.	Free E. J.
A - 11 0	.n = ,
Qualifier Lawal Luck	Date of Test Coupon 12.04.11
Welder Borda Ellevis	Date of Test Coupon 12.04.17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld